



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

4

D3391-015
Job Sheet 178431



Part No: D3391-015

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J SHEETS 8,10,11 IPP rev A 05.12.13 New issue EC IPP rev B 06.02.09 Dwg @ revD EC IPP rev C 07.03.13 dwg @revF ec IPP rev D 07.10.31 ecn 1053P EC IPP Rev:E ECN 1056 07-11-13 DD verified by: EC IPP Rev:F 08-09-10 revH as per dwg DD verified by:EC IPP Rev:G 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Crosstubes		M.D.
100	Mori Seiki	1 pcs	6/8/18	6/8/18	3.56	5.56	Mori Seiki TL-40		M.D.
110	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC2-1		M.D.
120	CNC Vertical Machining	1 pcs	6/8/18	6/8/18	0.00	2.57	HAAS1-3		M.D.
130	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Machining-2		M.D.
140	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC8 Machining-2		M.D.
150	Skidtubes	1 pcs	6/8/18	6/8/18	0.00	2.07	Skidtubes-3		M.D.
160	CNC Bend Skidtubes	1 pcs	6/8/18	6/8/18	0.00	2.57	CNC Bend Crosstube		M.D.
170	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC5		M.D.
180	Skidtubes	1 pcs	6/8/18	6/8/18	0.00	2.07	Skidtubes-4		M.D.
190	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC5		M.D.
200	HandFinish	1 pcs	6/8/18	6/8/18	0.00	0.60	HandFinish1		M.D.
205	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC7-2		M.D.
210	Skidtubes	1 pcs	6/8/18	6/8/18	0.00	2.07	Skidtubes-4		M.D.
220	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC5		M.D.
225	HandFinish	1 pcs	6/8/18	6/8/18	0.00	0.60	HandFinish2		M.D.
230	SprayPaint	1 pcs	6/8/18	6/8/18	0.00	0.63	Spray Paint		M.D.
240	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC14		M.D.
250	HandFinish	1 pcs	6/8/18	6/8/18	0.00	0.60	HandFinish4		M.D.
260	QC	1 pcs	6/8/18	6/8/18	0.00	0.00	QC5		M.D.
270	Packaging	1 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-1		M.D.
280	QC21-SA	1 Ea	6/8/18	6/8/18	0.00	0.00	QC21		M.D.

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ****REMOVE STEADY REST AND MACHINING
Descriptions: MARKS****

120 - 1-Machine as per Folio FA 599 Rev: ____ & Dwg D3391 Rev: ____ 2-Debur

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 **Add tangent as per Folio-11**

160 - Form as per Dwg D3391 **Folio -11**

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391(All holes) 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . ****Do Not Open To Finished Size**** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5- Tranfer holes from D3391-013 for electric step 0.187" hole D3391 section cc-cc 6- Using DT10247 and drill holes for nutplates, Detail DD, open (5) forward wearplate holes 0.375", and c'sink 7-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ****SIX FARTHEST AFT HOLES ONLY** 8-C'bore section cc-cc and open to finish

SEP 17 2018

DAS
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Plex 5/31/18 12:51 PM Dart.lajeunesse.marie

SEP 19 2018

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order D

Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																					
Container No: S079224 Part: D3391 - 015 Job No: 178431 Serial No/Batch: S079224 Revision: _____ Inspector: _____ Exp Date: 06/08/2018 Instructions: _____ Date: 06/08/18																																																																					
1270 Aberdeen Street Hamden, CT 06430 TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																					
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size 9- Open float bag holes to 0.328" as per Dwg D3391, and c'sink 10-Debur

210 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 5080785 exp. date: 11/05/16 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Debur

225 - REALODINE AS PER PAR09-043

230 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: _____

250 - 1- Install nutplate using MS20601AD4W4 (qty12) in the six most forward holes and MS20601AD4W9 (qty8) in the four aft holes. Rivet nutplates as per section TT on sheet 11. 2-Install inserts per dwg D3391 3-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 _____ Sikaflex expiry date: _____ 4- INSTALL WEARPLATE AS PER DWG

8139427

Job BOM

005616

Part / Item	Component Name	Quantity	Operation	Container
D6014-090	Aluminum Extrusion	1 Ea (1 ea)	90-Start up Operation	
NAS1149C0332R	Washer	10 Ea (10 ea)	90-Start up Operation	
D3670-4-200	Bushing	14 Ea (14 ea)	210-Skidtubes	<u>5071663</u>
ALS4-1032-130	Rivnut	8 Ea (8 ea)	250-HandFinish	<u>5081067</u>
ALS4-1032-225	Rivnut	4 Ea (4 ea)	250-HandFinish	<u>5007279</u>
ALS4-428-165	Insert	4 Ea (4 ea)	250-HandFinish	<u>5058138</u>
AN3C4A	Bolt	6 Ea (6 ea)	250-HandFinish	<u>5058145</u>
AN3C5A	Bolt	4 Ea (4 ea)	250-HandFinish	<u>5095233</u>
D2646	Aft Cap	1 Ea (1 ea)	250-HandFinish	<u>5095211</u>
D3672-1	Washer, Phenolic	2 Ea (2 ea)	250-HandFinish	<u>1116325-1-102</u>
D4095-047	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	<u>F163255-1</u>
D4095-049	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	<u>5025094</u>
MS20601-AD4W3	Rivet	<u>12</u> Ea (12 ea)	250-HandFinish	<u>5018296</u>
MS20601-AD4W7	Rivet	8 Ea (8 ea)	250-HandFinish	<u>5092687</u>
MS21075L5	Nut Plate	10 Ea (10 ea)	250-HandFinish	<u>1137087</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	21	0
	NAS1149C0332R	10	6,681	0
210-Skidtubes	D3670-4-200	14	32	0
250-HandFinish	ALS4-1032-130	8	13,829	0
	ALS4-1032-225	4	4,997	0
	ALS4-428-165	4	108	0
	AN3C4A	6	1,908	0
	AN3C5A	4	1,947	0
	D2646	1	90	0
	D3672-1	2	1,088	0
	D4095-047	1	27	0
	D4095-049	1	36	0
	MS20601-AD4W3	12	807	0
	MS20601-AD4W7	8	169	0
	MS21075L5	10	454	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
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DART AEROSPACE LTD		Work Order: 178431
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		Vern	
3.500	+/-0.010	3.501	✓		Vern 08	
Ø3.200	+/-0.010	3.193			5" 14" 05	
Ø3.750	+/-0.010	3.749	✓		"	
30° x 0.060 chamfer	+/-0.010	.060	✓		Vern 08	
88.93	+/-0.030	88.93	✓		Tape	

Measured by: M.D	Date: 2018-06-07
Audited by: [Signature]	Date: 18-06-08

HAAS Section						
1.526	+0.000/-0.030	1.519	✓		Vernif	
7.500	+/-0.010	7.502	✓		Vernif	
27.750	+/-0.010	27.750	✓		Tape	
31.750	+/-0.010	31.750	✓		Tape	
35.250	+/-0.010	35.250	✓		Tape	
3.300	+/-0.010	3.300	✓		Vernif	
0.200	+/-0.010	.198	✓		Pinage	
3.520	+/-0.010	3.522	✓		Vernif	
0.687	+0.010/-0.000	.688	✓		Vernif	
R0.062	+/-0.010	R0.062	✓		Gaborit	
Ø0.484	+0.005/-0.001	.485	✓		Pinage	

Measured by: M.M. [Signature]	Date: 2018/06/11
Audited by: DAS	Date: 18-06-13

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041016**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041016
PO Date: 9/14/18
Due Date: 9/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177479	D3391-011	Fwd Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
2	178458	D3391-013	Mid Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
	178430			Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
Sub Total:							2	0	2		\$760.00
3	178431	D3391-015	Aft Tube Assembly : Various STC's	Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
	178460			Firmed	-	9/17/18	1 pcs	0 pcs	1 pcs	\$380.00/pcs	\$380.00
						1 X SEP 19 2018					
Sub Total:							2	0	2		\$760.00
Grand Total:										\$1,900.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/17/18 9:00 AM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Atelier Debosselage
358 Principale
Calumet, QC J0V 1B0 Canada
Phone: 819 242 5633 **Fax:**

SHIPPER

Shipper No: 624
Shipper Date: 9/17/18
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: D3391-011
Cust Part No:
Reference No:
Part Information Note: DWG REV J SHEETS 3,5 IPP A 05.09.13 New issue
KJ/JLM IPP B IPP C 07.03.13 revF dwg ec IPP D
07.11.01 ecn1053P EC IPP Rev:E ECN 1056 07-11-
12 DD verified by:EC IPP Rev:F 08-09-08 new
process (ecn 08-510) DD verified by:EC IPP Rev:G
08-09-10 revH as per dwg DD verified by:EC IPP
Rev:H 10.04.07 add part in bom DD verified by:JLM
IPP Rev:I 11.11.14 AS PER REV.I DD verified by:JLM
Name: Fwd Tube Assembly
Product Family: Landing Gear
Piece Weight: 0 lbs
Alloy Type:
Alloy - Temper: -
Description: Various STC's
Quantity:
Drawing No:
Program:
Program Customer:
Addl Docs:
Commercial: Product Line: Landing Gear - Spare
Primary OEM Application: Bell
Manufacturer: DART
Advertised on web?: Yes

OPERATION

Operation: Outsource - 245
Description:
Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
D3391-011	Outsource	PO041016	177479	S076677		0	0	1
D3391-013	Outsource	PO041016	178458	S077079		0	0	1
			178430	S078351		0	0	1
D3391-015	Outsource	PO041016	178431	S079224		0	0	1
			178460	S079256		0	0	1
			Total	5		0	0	5

Driver Signature

Customer Copy

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